

Date: Tuesday, 4/18/2006 9:58:40 AM
 User: Kim Johnston

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 26647 A
 Estimate Number : 10337
 P.O. Number : N/A Part Number : D28073
 This Issue : 4/18/2006 S.O. No. : N/A Drawing Number : D2807 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 26625 Material : N/A
 Due Date : 4/30/2006 Qty: ~~60~~ 56 Um: Each
 Written By : *SKY COMMUNITY Beldy*
 Checked & Approved By : *06.04.18*
 Comment : Est A 05.06.02 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 6.5646 f(s)
 Material: 303 Round Bar Ø0.750"
 (M303R0.750)

A100806

Batch: *06/05/26*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE
 Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

MS 06/05/27 54

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/05/27 54

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1
 Machine as per Folio FA528 and Dwg D2807 Dwg Rev: L
 Folio Rev: AA N/A Machined Manually

2-Deburr

06/07/31 J.F. 06/07/31 54

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *06/07/31 J.F. 06/07/31 54*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 06/18/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 9:58:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 26647

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G. 06/07/31 54

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51387*

LB 06/08/01 51387 06/07/31

(54)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

LD 06/08/02 (51)

Job Completion



106108102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

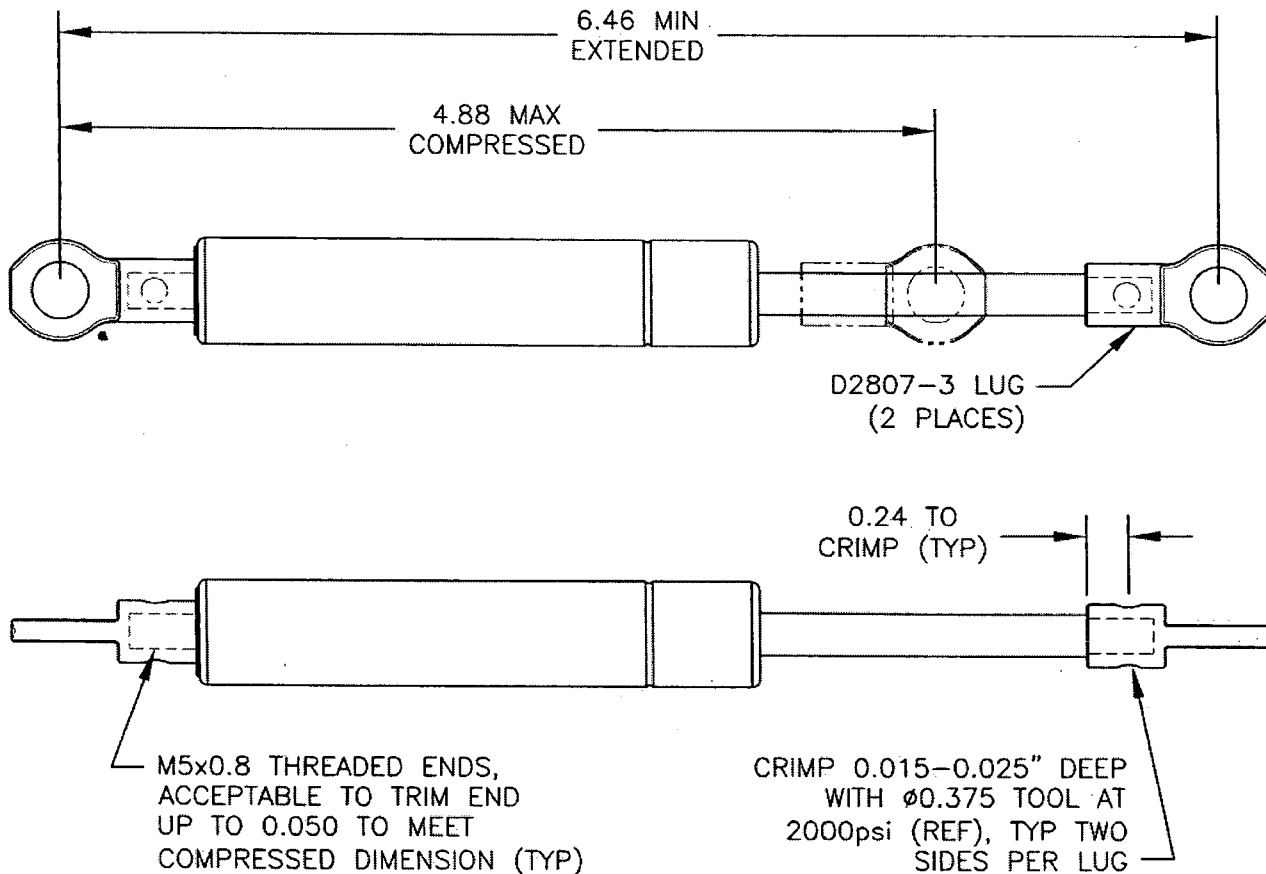
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
					11/1/2011			

NOTE: Date & initial all entries

DART

RELEASED
05.06.16

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CP	CP	DRAWING NO.	REV. C
CHECKED	APPROVED	D2807	SHEET 1 OF 2
DATE		TITLE	SCALE
05.05.25		GAS SPRING	1:1
A	00.11.03	NEW ISSUE	
B	05.03.16	ADD FINISH	
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG	

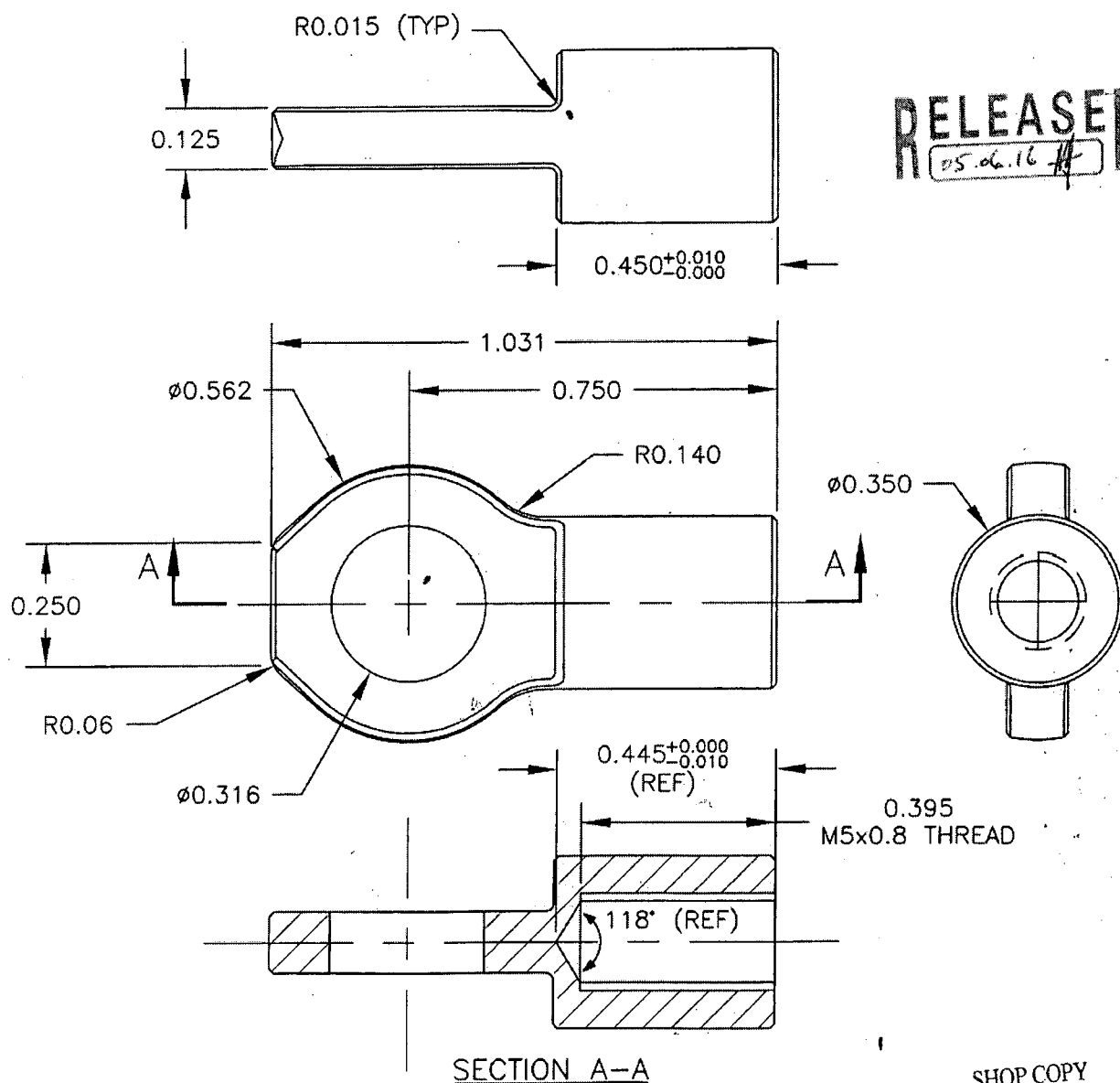


D2807 GAS SPRING

- SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS
SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26647

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

